

Date: Friday, 25/07/2008 4:20:58 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 40767		
Estimate Number	: 13516		
P.O. Number	:	Part Number	: D21972
This Issue	: 25/07/2008 S.O. No. :	Drawing Number	: D2197 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	:	Material	:
Written By	:	Due Date	: 20/08/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JUD 08.7.25</u>		
Comment	: Est Rev:A 08-07-24 new issue ec verified by:dd		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.1457 sf(s)/Unit Total : 0.2915 sf(s)
 304 SS Sheet 0.063" thick
 batch: 108724 1B 8-8-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2196
 Dwg Rev: C
 Prog Rev: C

1B 8-8-21(3)

2-Deburr if necessary

1B 8-8-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/08/2008 (X3)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per dwg D2196

JB 08/08/2008 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:58 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40767

Part Number: D21972

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/25 (x3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: 18

5/8/25

(3X)

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



u 08-08-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

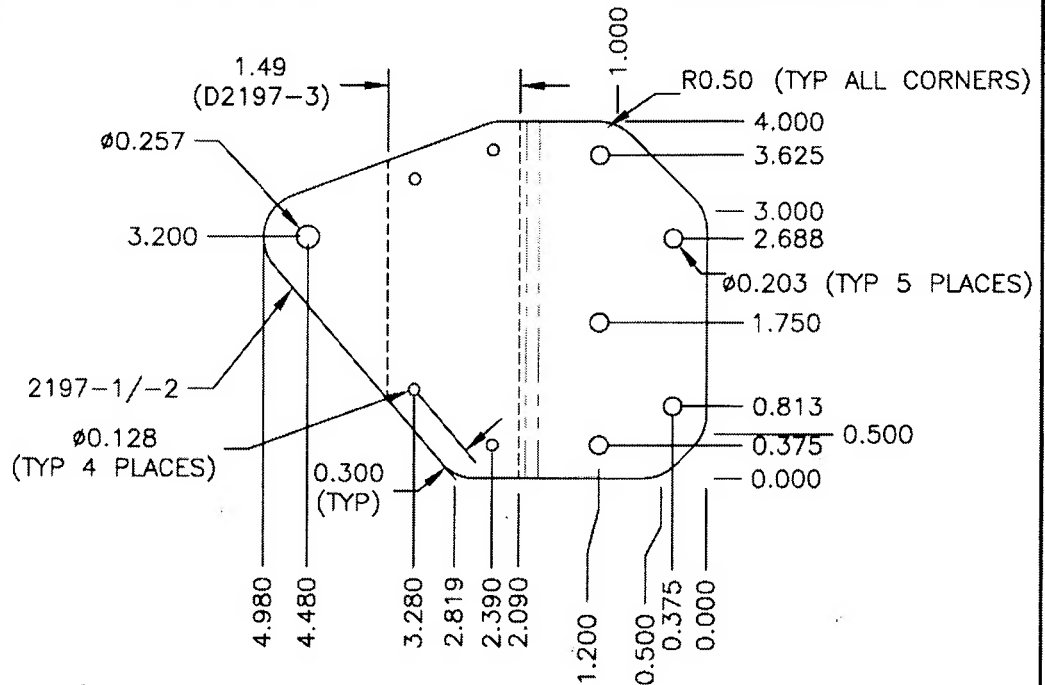
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2197	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2197-3 NOW 0.5" THICK	

D2197-1/-2/-3
FLAT PATTERN



D2197-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2197-3

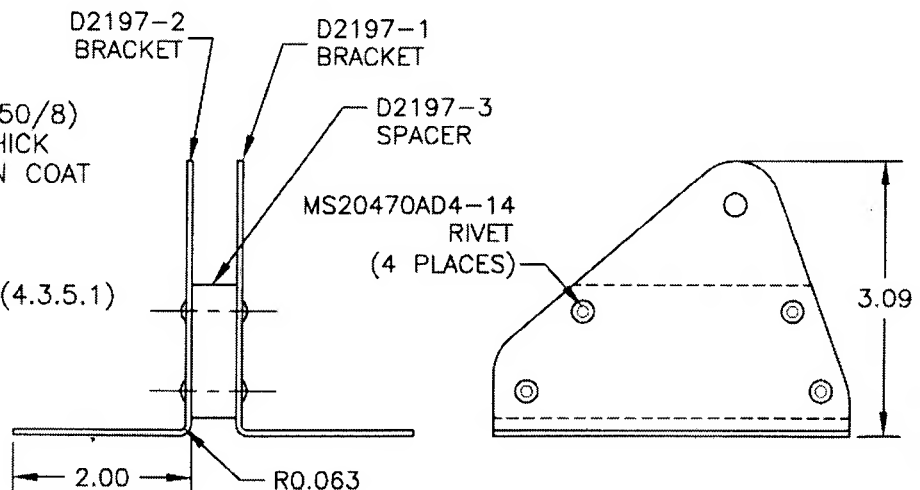
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2197 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2197 BRACKET
(ASSEMBLY)

SHOP COPY
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WITHOUT NOTICE

WORK ORDER

NO. 40162

DART AEROSPACE LTD		Work Order: 40761
Description: BRACKET		Part Number: D2197-2
Inspection Dwg: D2197-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.130	X			
Ø .203	+ .005 - .001	.204	X			
Ø .257	+ .006 - .001	.259	X			
.375	+/- .010	.375	X			
1.200	+/- .010	1.200	X			
2.390	+/- .010	2.395	X			
3.280	+/- .010	3.284	X			
4.480	+/- .010	4.480	X			
4.980	+/- .010	4.980	X			
.375	+/- .010	.375	X			
.813	+/- .010	.813	X			
1.750	+/- .010	1.753	X			
2.688	+/- .010	2.686	X			
3.625	+/- .010	3.625	X			
4.000	+/- .010	4.004	X			
.063	+/- .010	.061	X			

Measured by: IB	Audited by: S	Prototype Approval: 1/4
Date: 8-8-21	Date: 08/08/21	Date: 8/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	